

FIG. 1 (a)

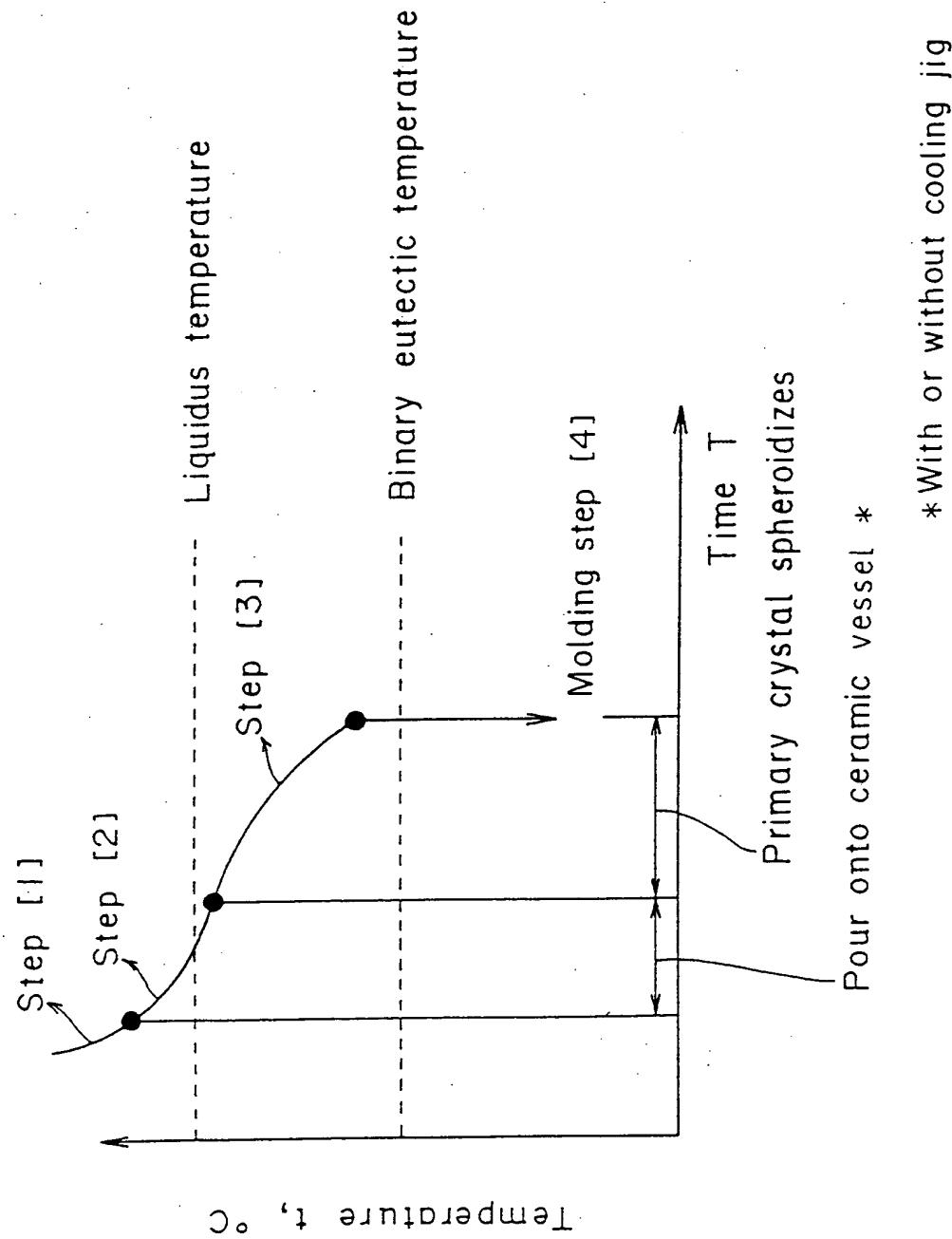
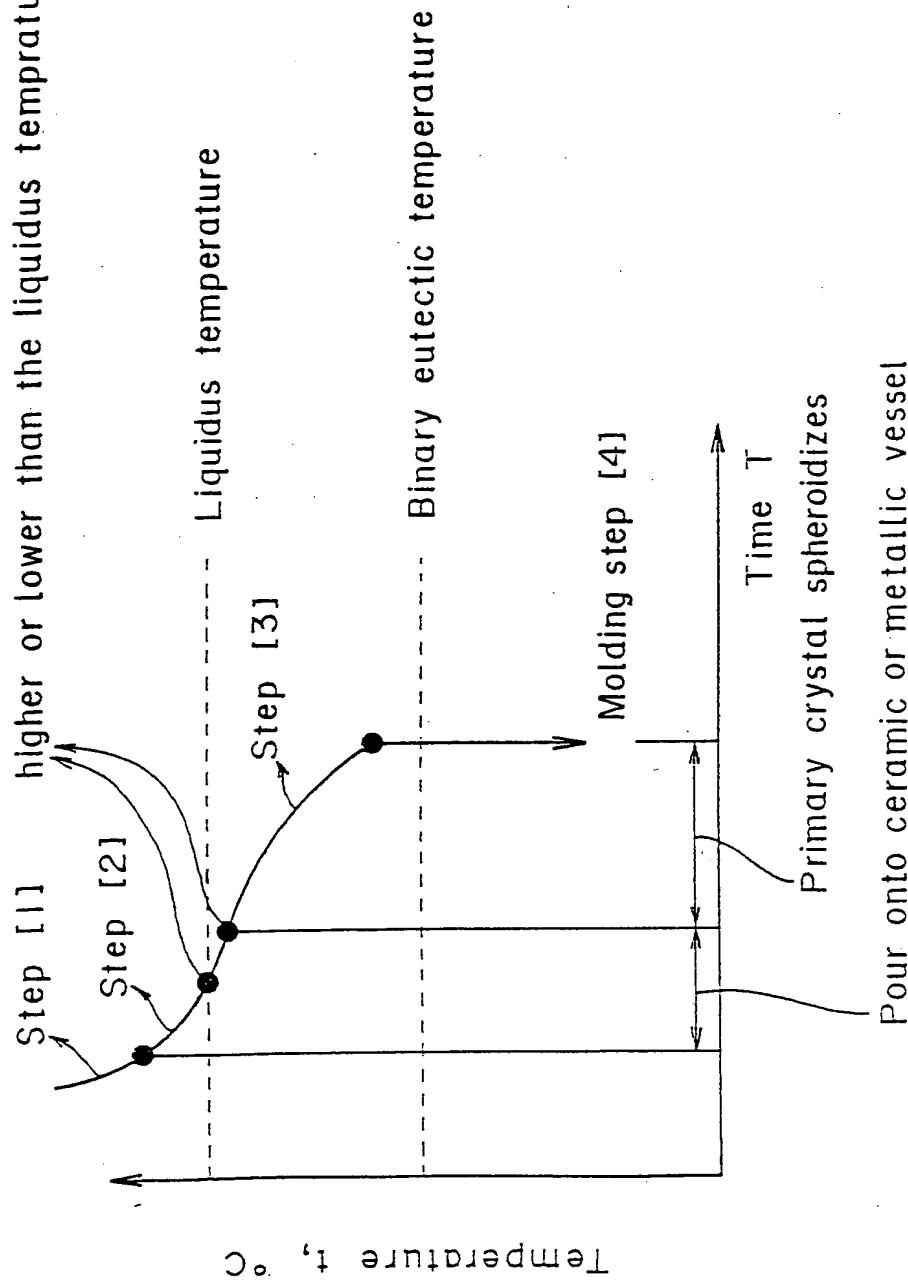


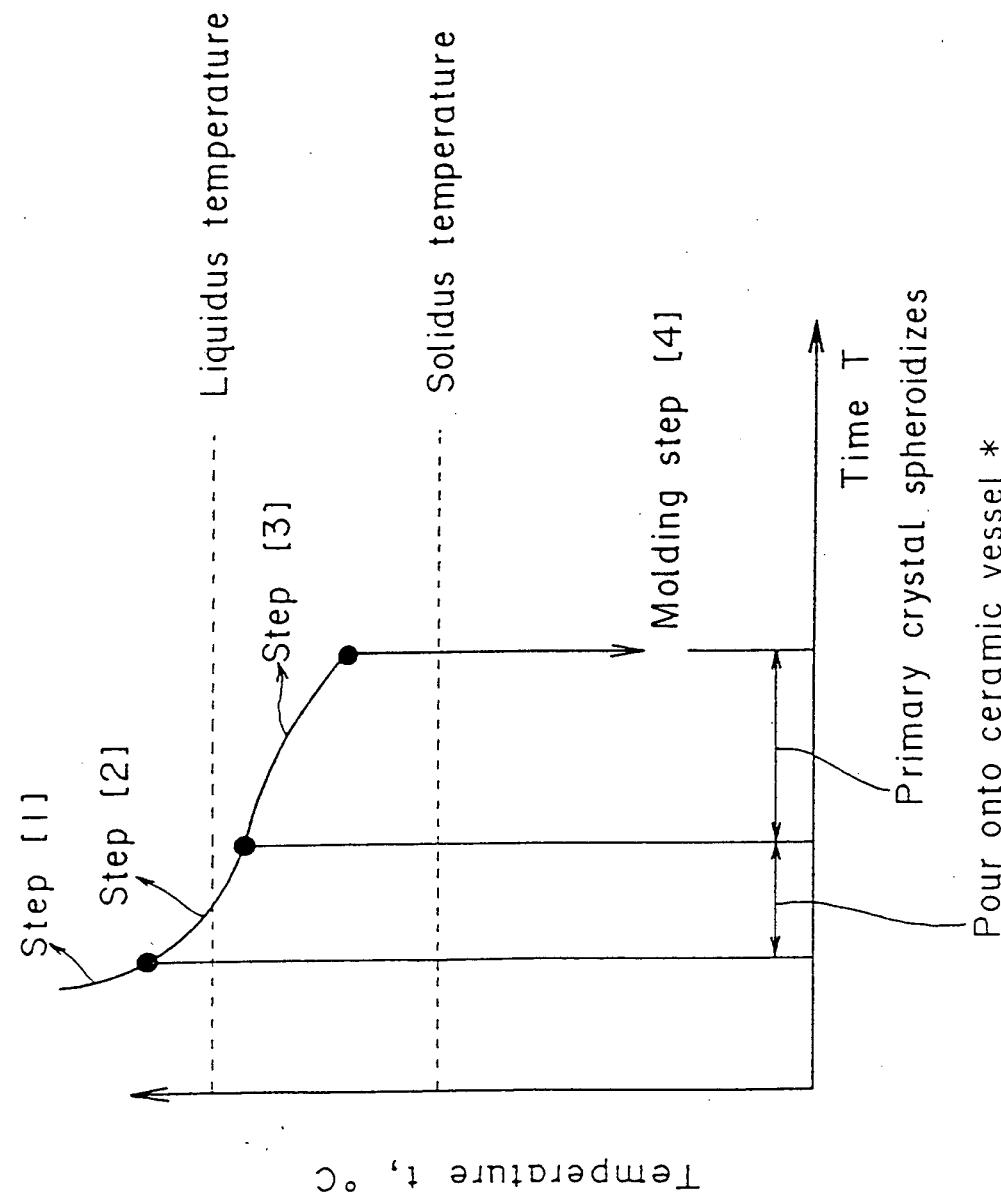
FIG. 1 (b)

Temperature of melt depends on the case and may be higher or lower than the liquidus temperature



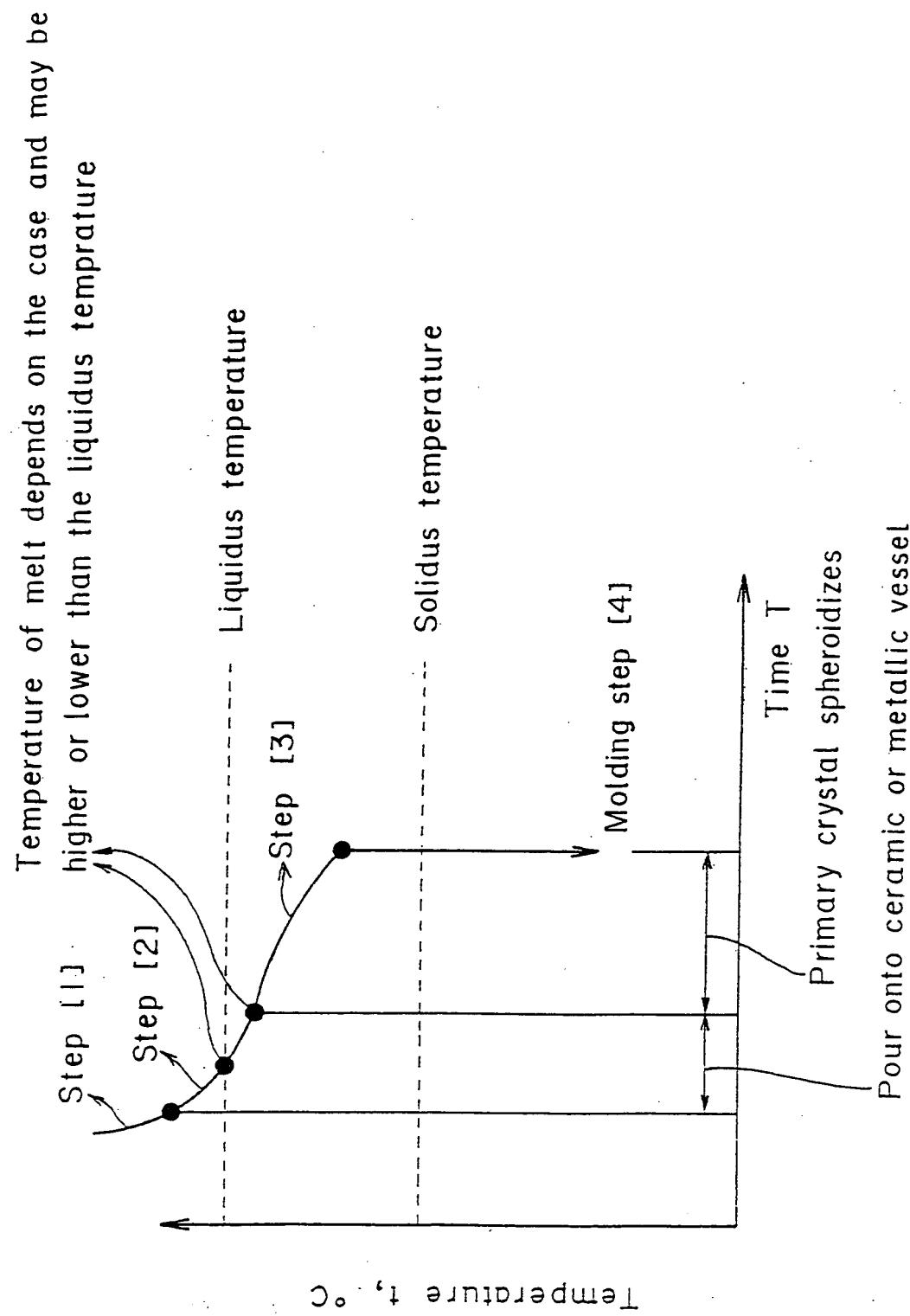
APPROVED	O.G. F.G.
BY	CLASS SUBCLASS
CRAFTSMAN	

FIG. 2 (a)



*With or without cooling jig

FIG. 2 (b)



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BY	CLASS SUBCLASS
DRAFTSMAN	

FIG. 3 (a)

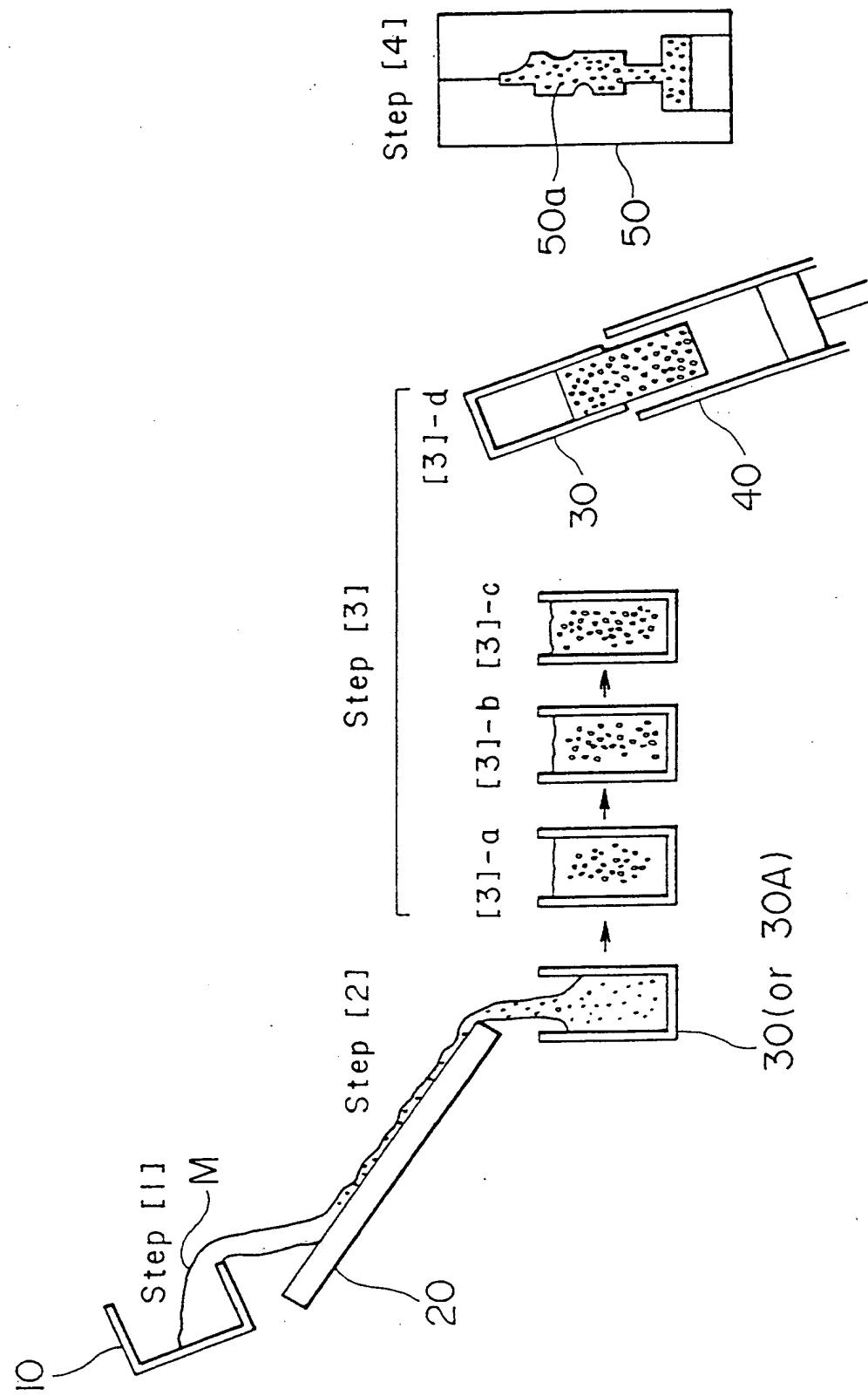


FIG. 3(b)

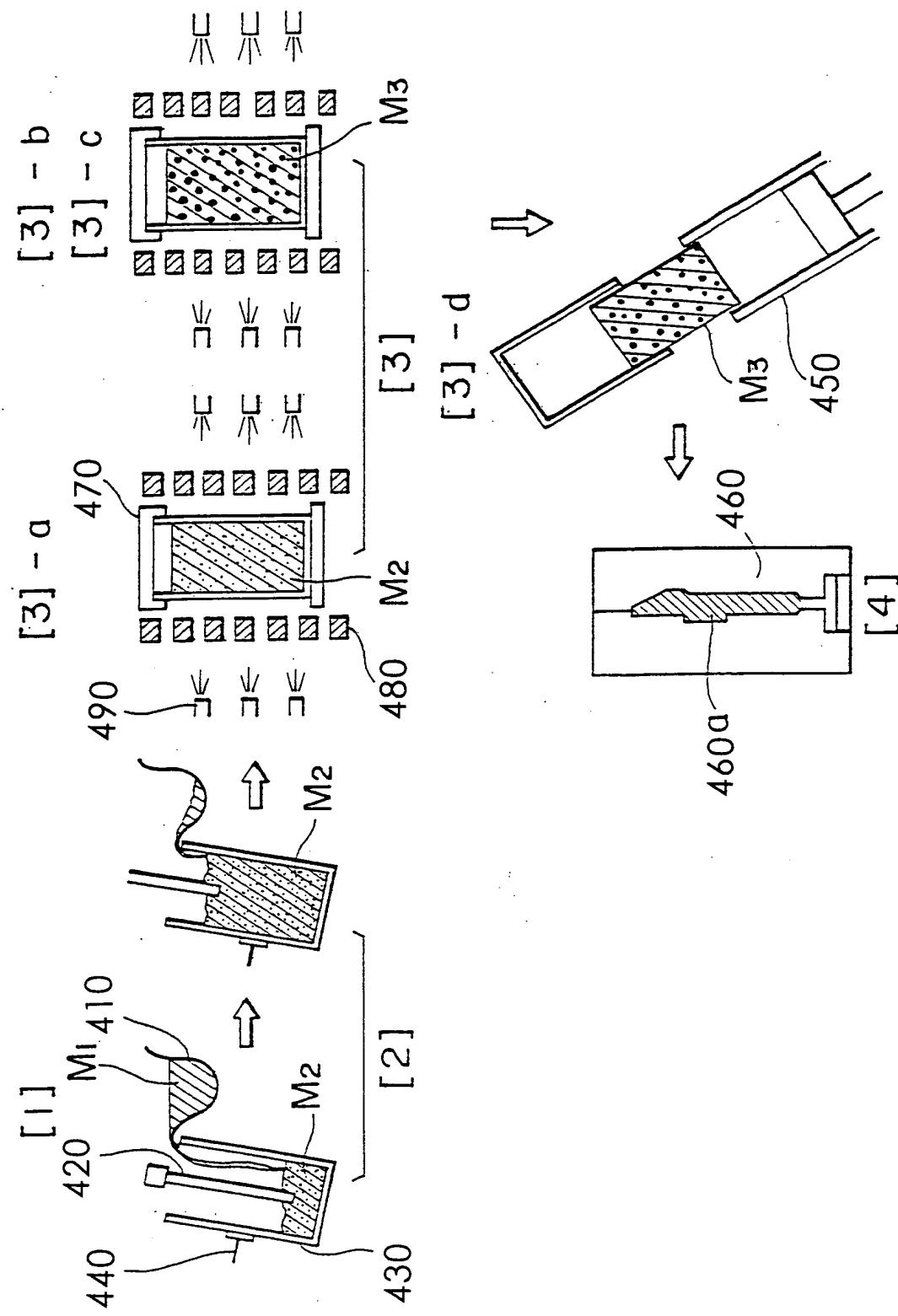


FIG. 5(a)

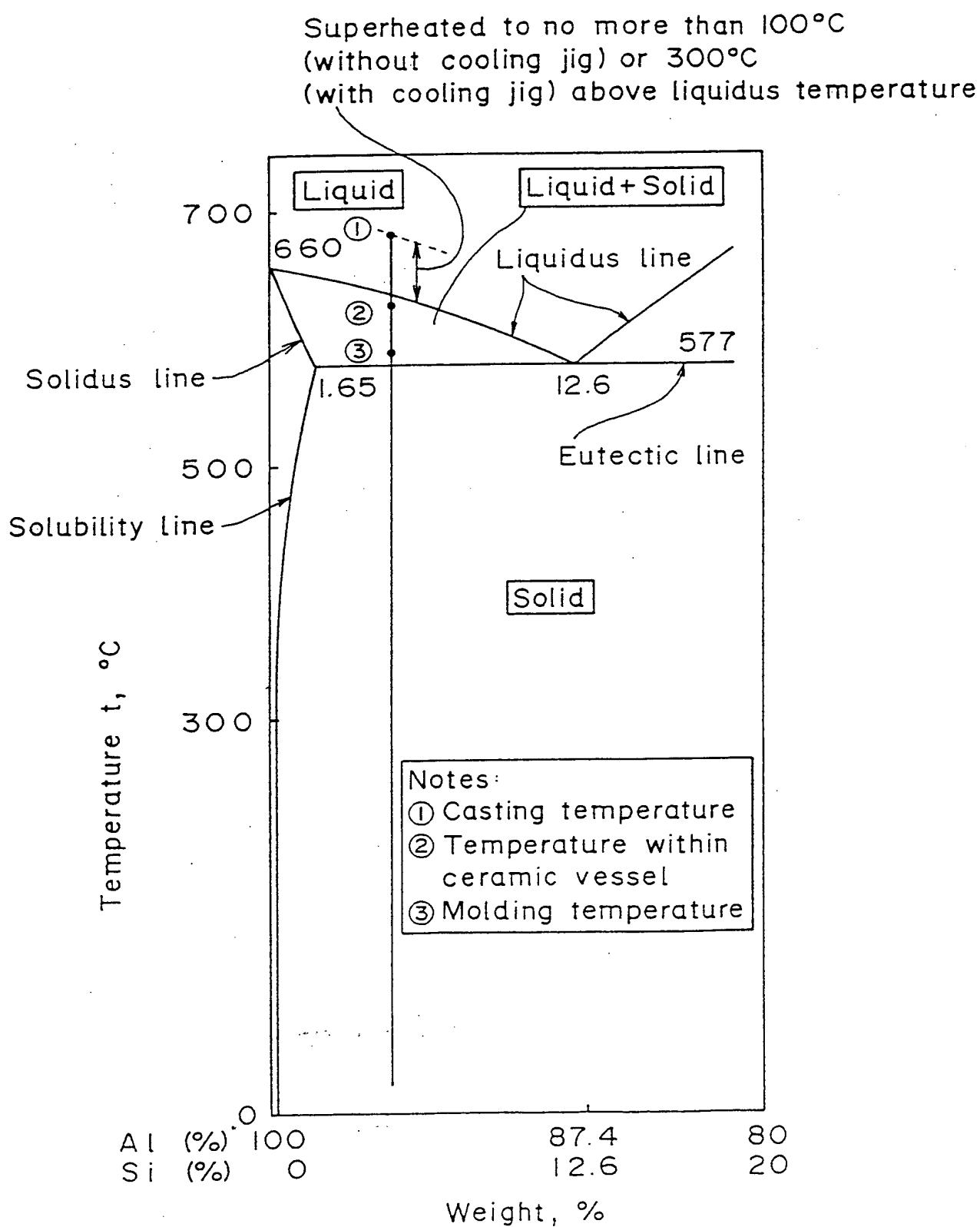


FIG. 5 (b)

Temperature of melt depends on the case and may be higher or lower than the liquidus temperature

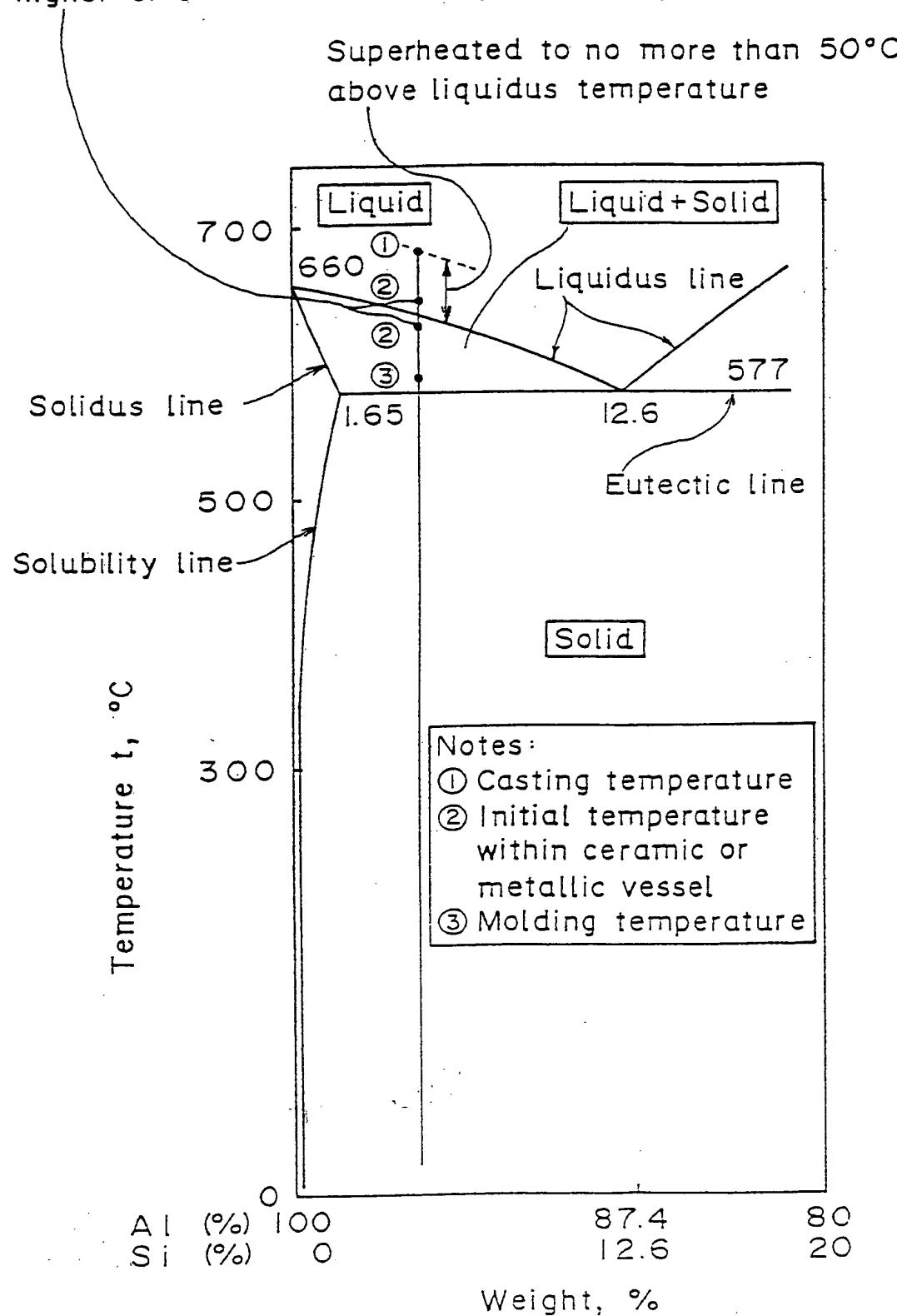


FIG. 6(a)

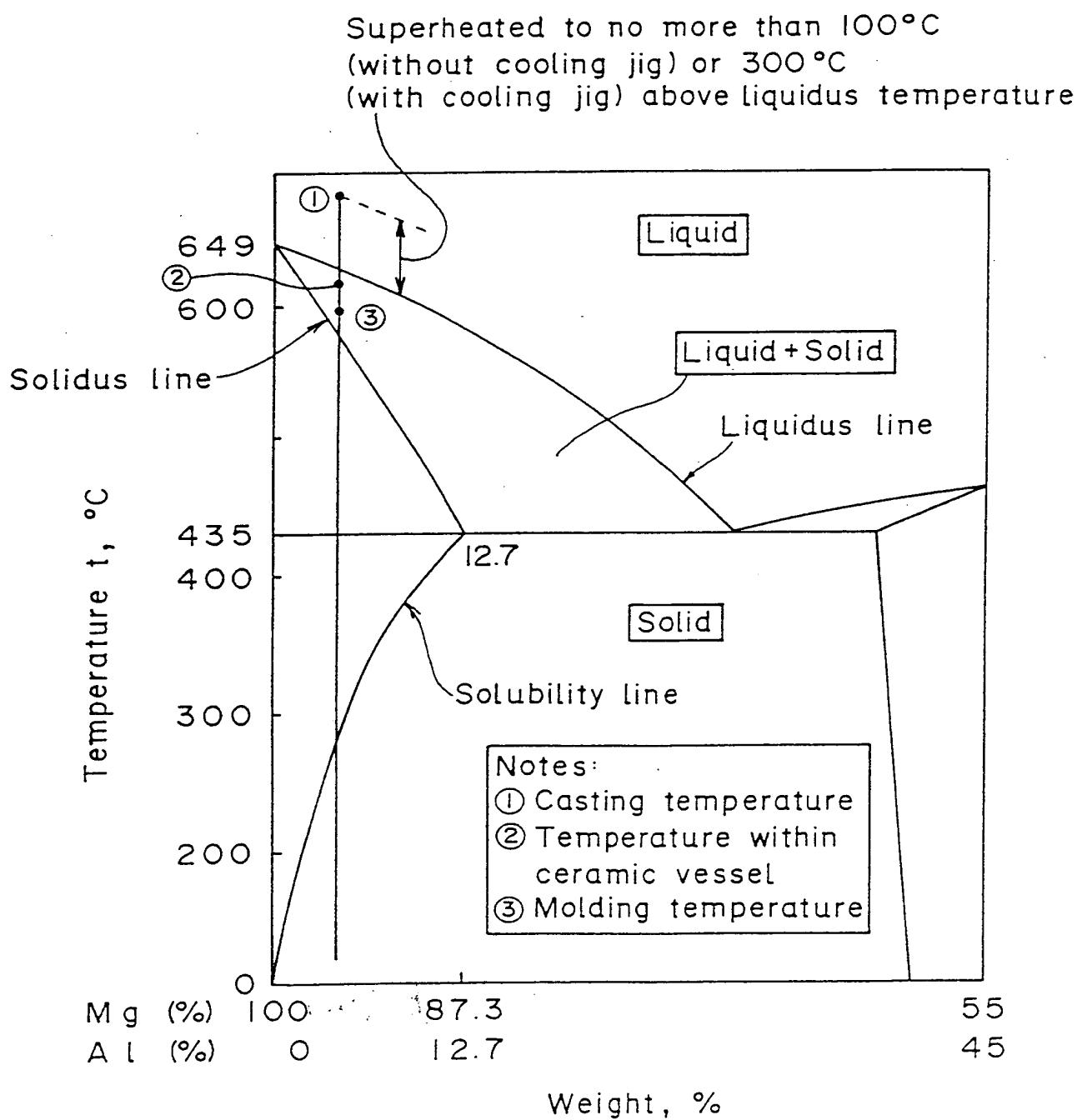


FIG. 6 (b)

Temperature of melt depends on the case and may be higher or lower than the liquidus temperature

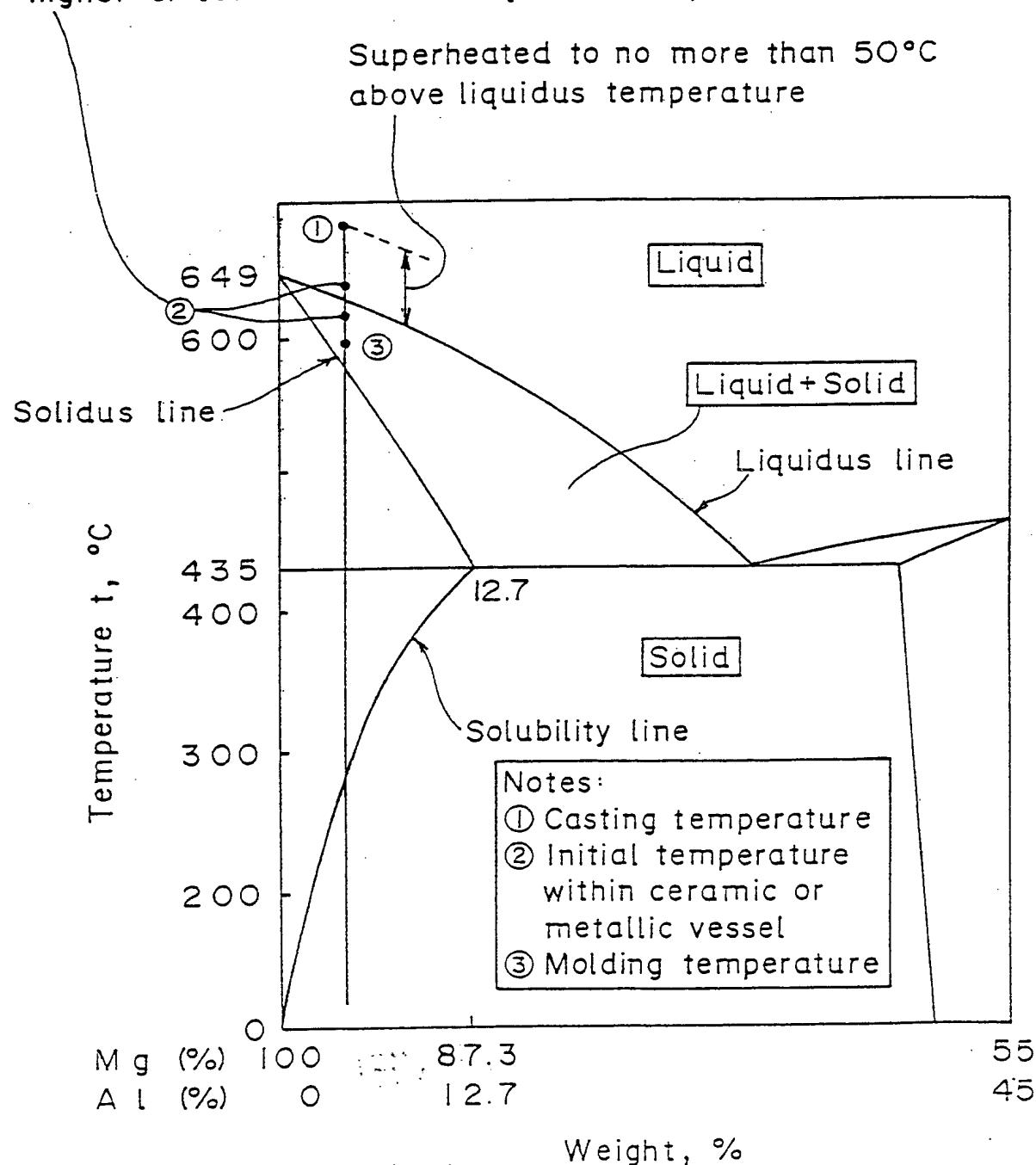
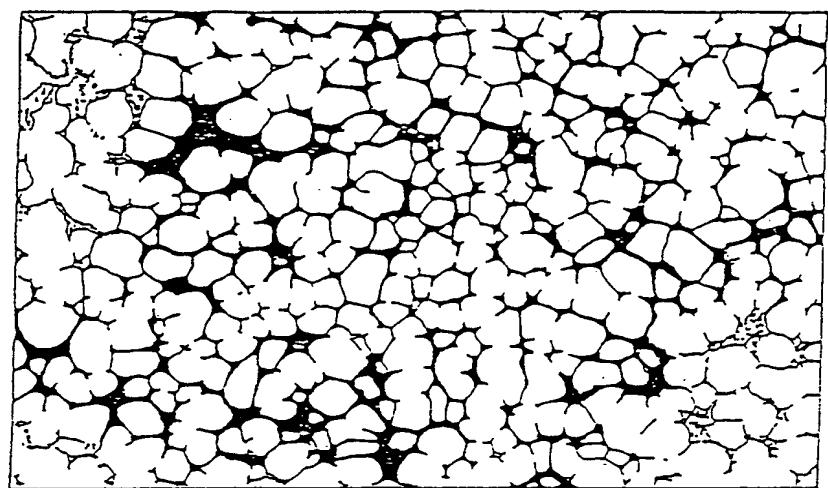
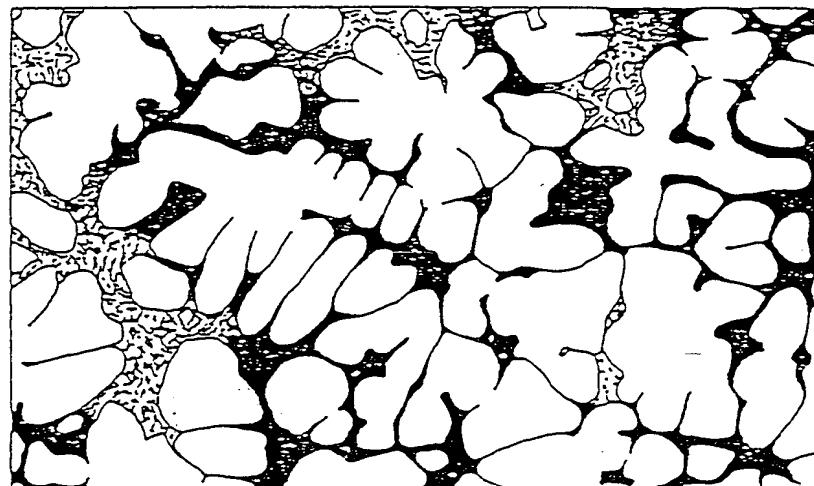


FIG. 7(a)



100 μ m

FIG. 8(a) Prior Art



100 μ m

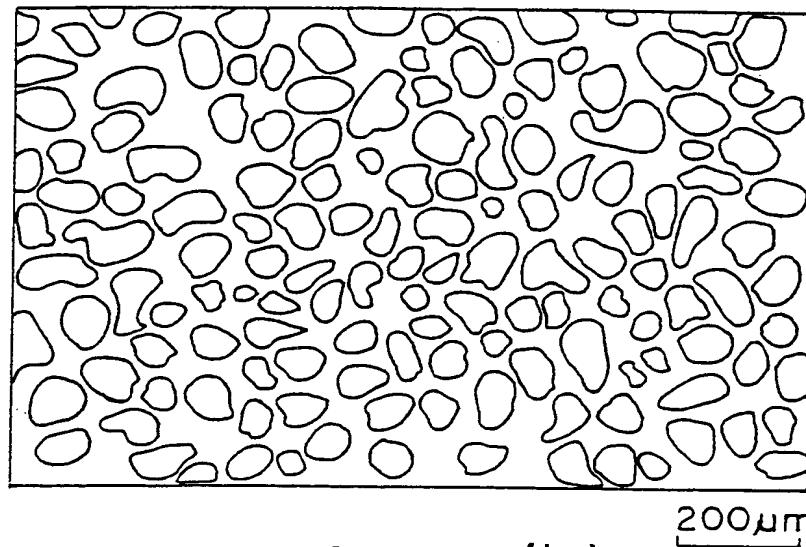


FIG. 7(b)

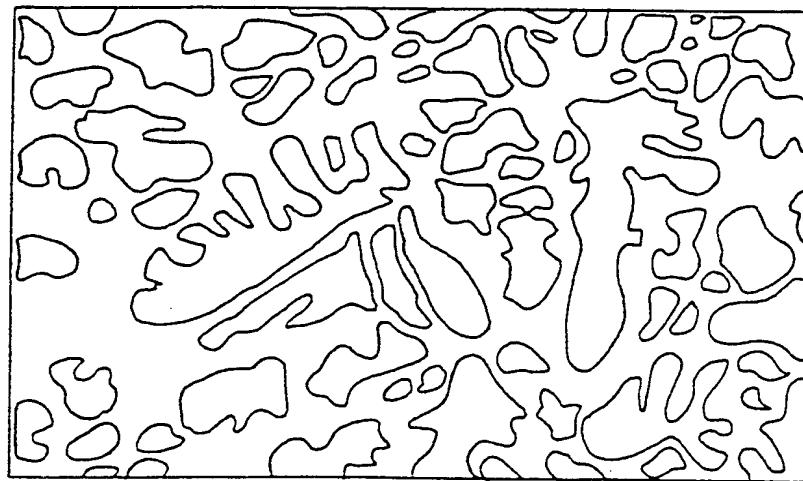


FIG. 8(b)
PRIOR ART

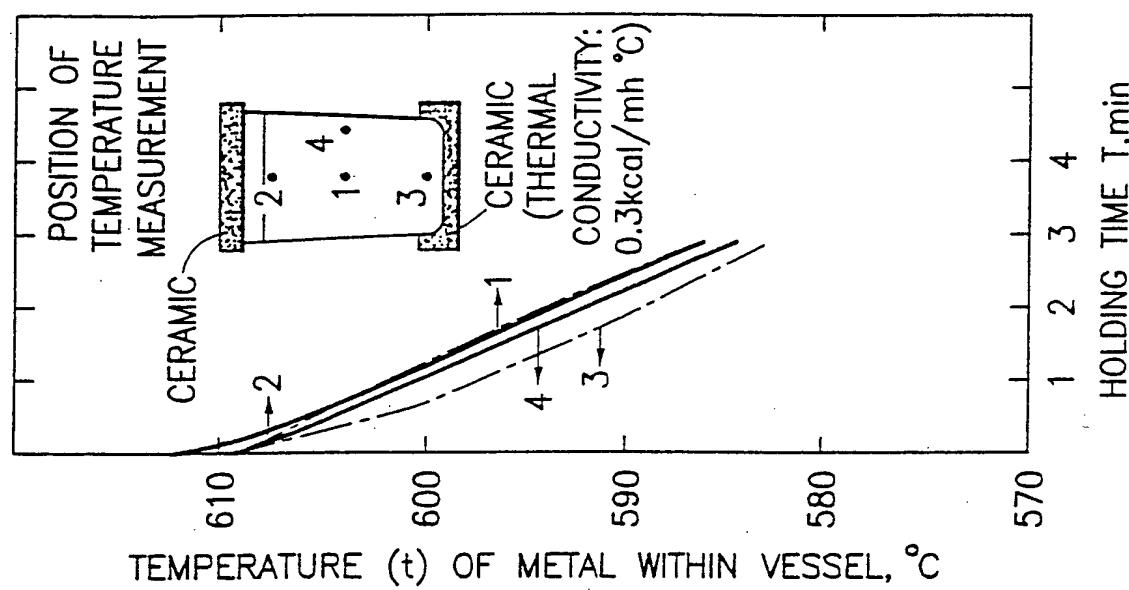


FIG. 75(b)

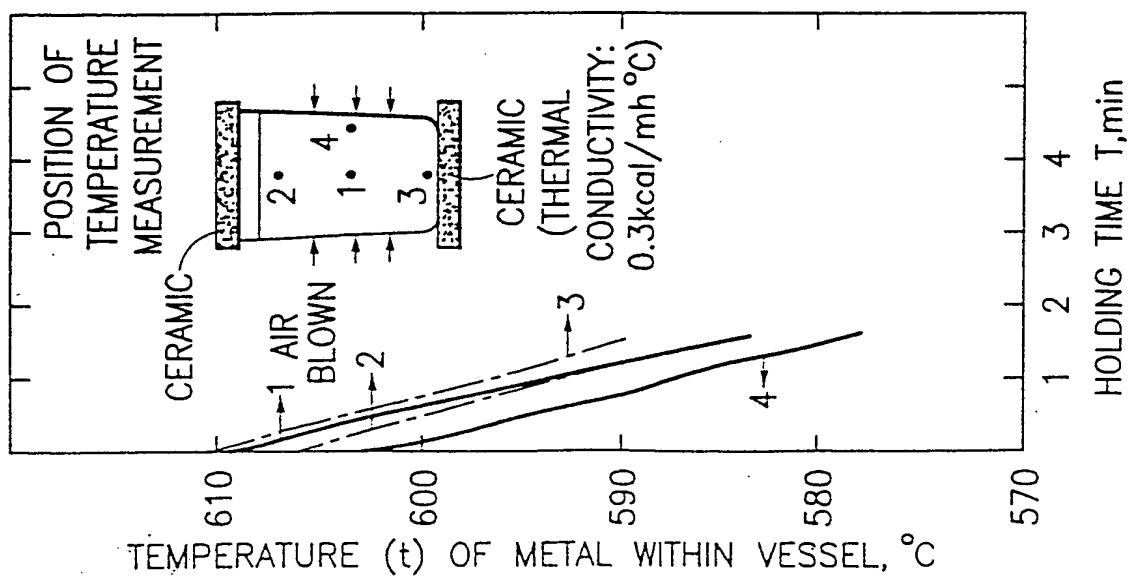
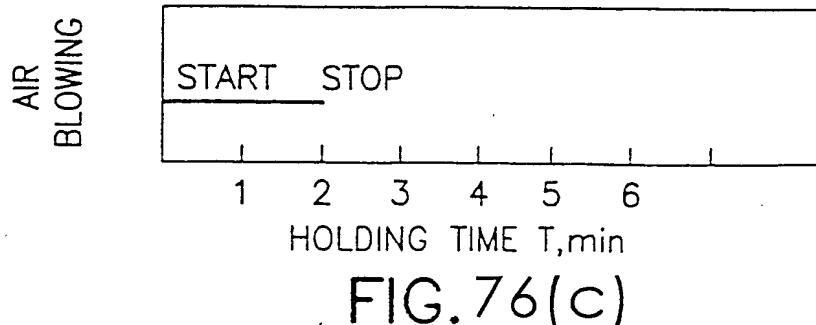
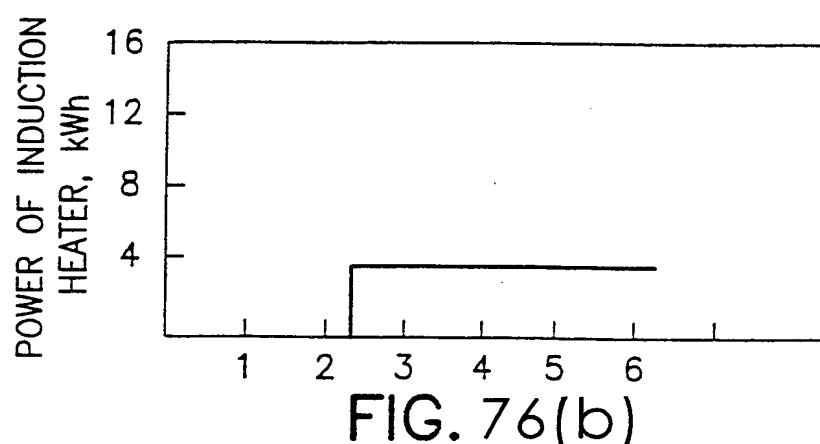
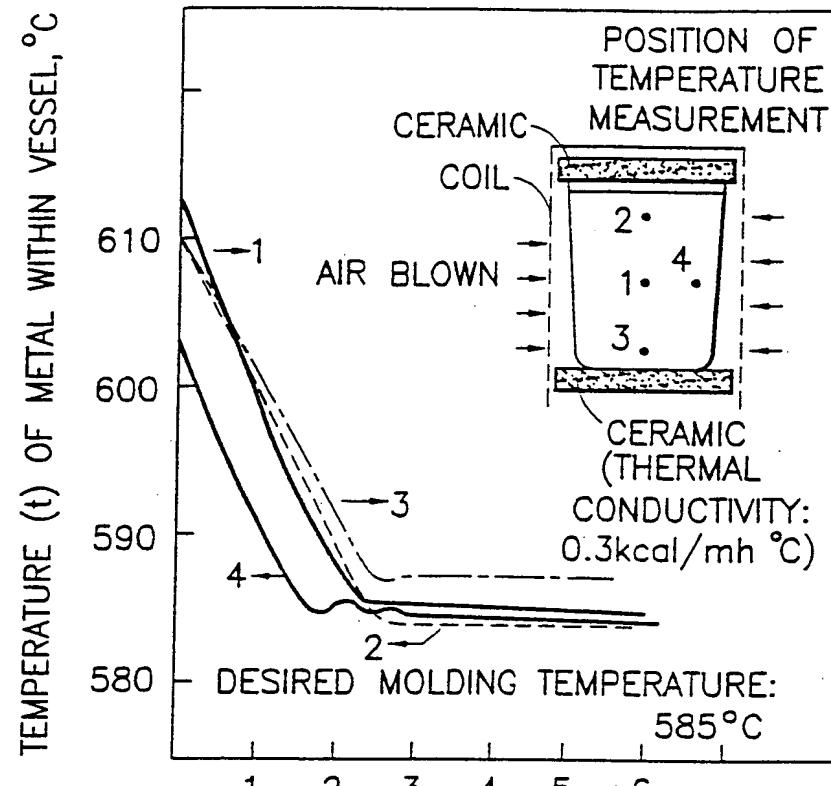
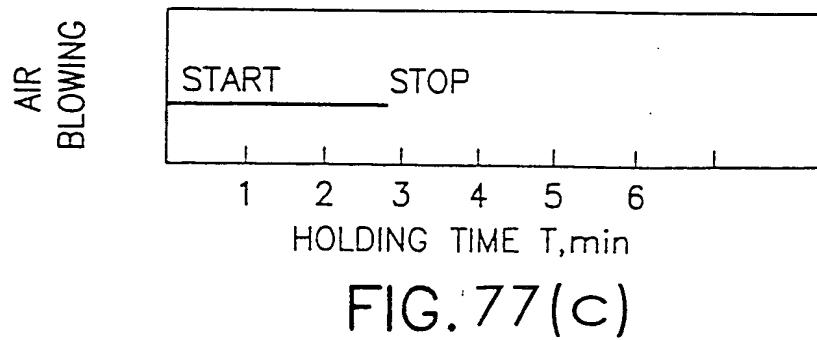
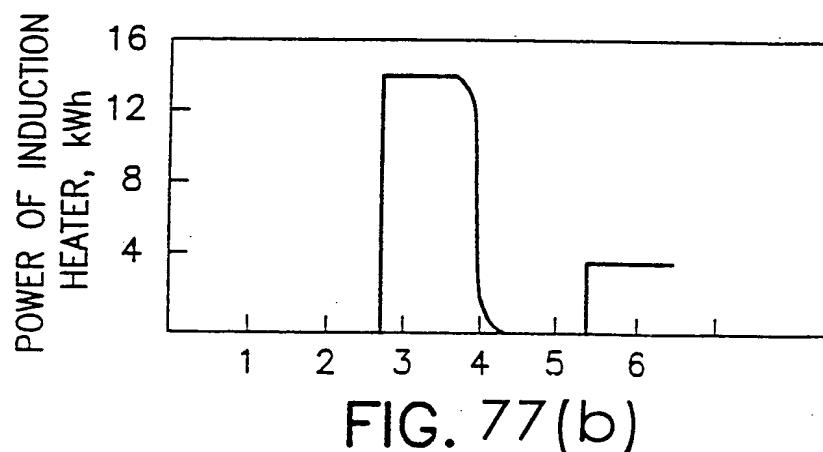
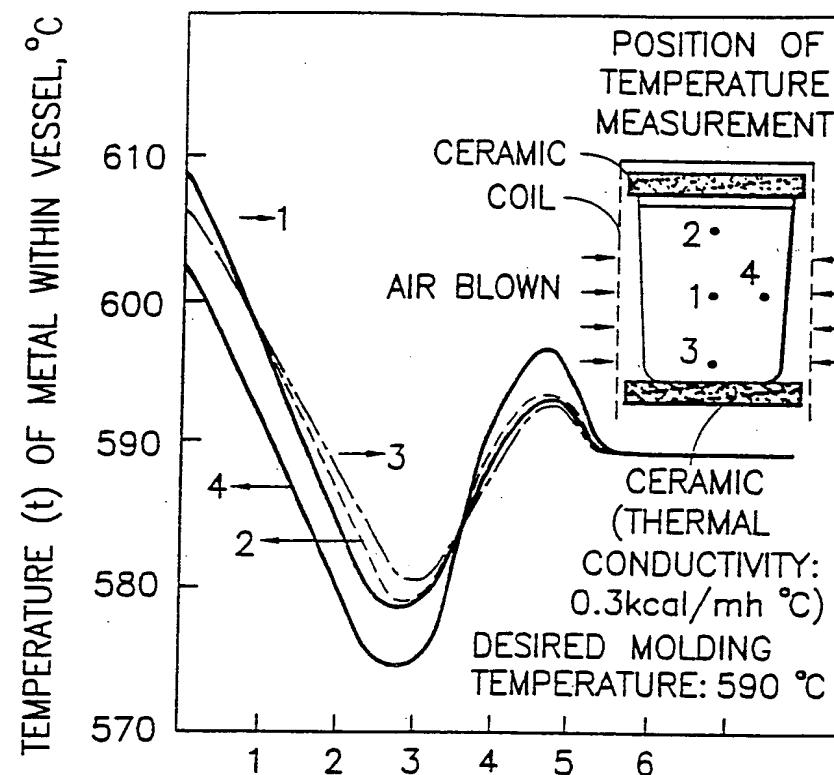


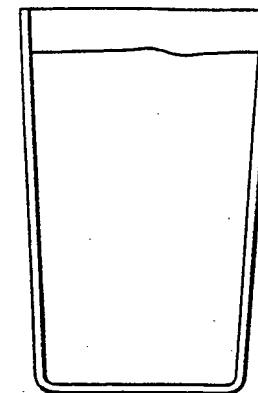
FIG. 75(a)

APPROVED	C. G. FIG.
BY	CLASS SUBCLASS
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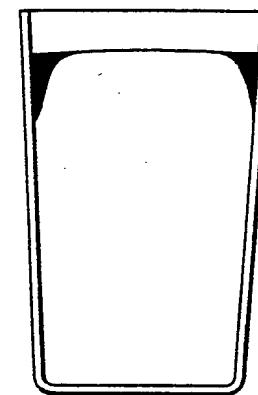


APPROVED	C. C. F.
BY	CLASS
DRAFTSMAN	SUBCLASS



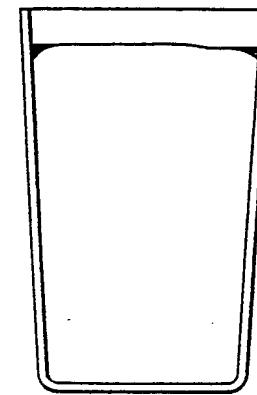
WHEN MOLDING TEMPERATURE IS REACHED

FIG. 78(a)



WHEN HEATED AND HELD WITH rf INDUCTION
HEATER (AT 8 kHz) FOR 20 min AFTER
MOLDING TEMPERATURE WAS REACHED

FIG. 78(b)

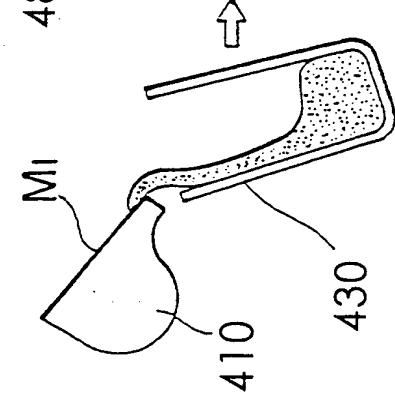


WHEN HEATED AND HELD WITH rf INDUCTION
HEATER (AT 40 kHz) FOR 20 min AFTER
MOLDING TEMPERATURE WAS REACHED

FIG. 78(c)

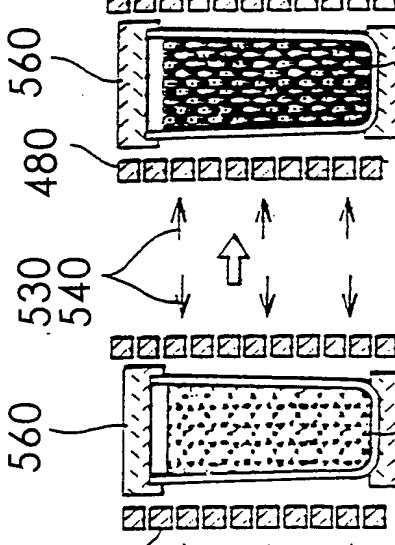
FIG. 79

Step [1] Step [2]

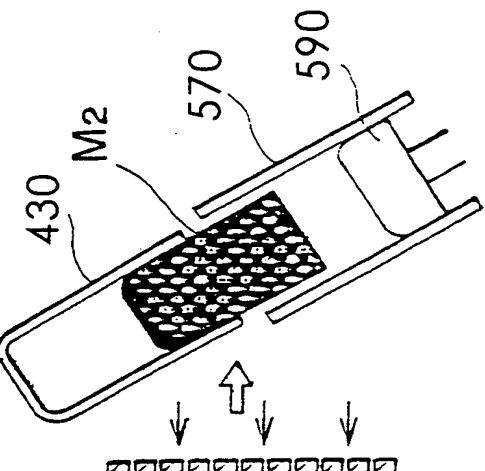


Step 3

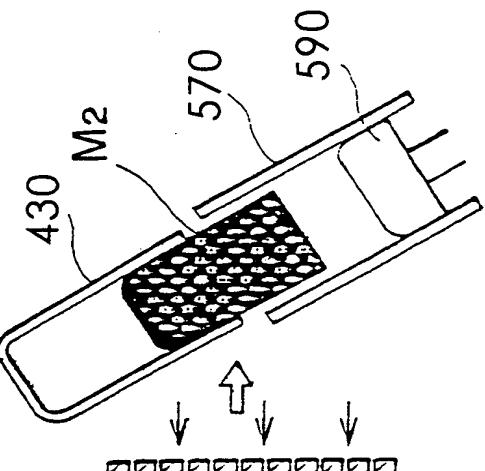
[3]-a



[3]-b



[3]-c



Step [4]

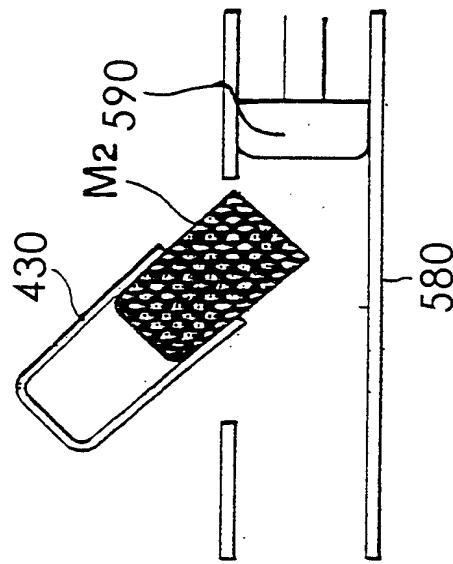
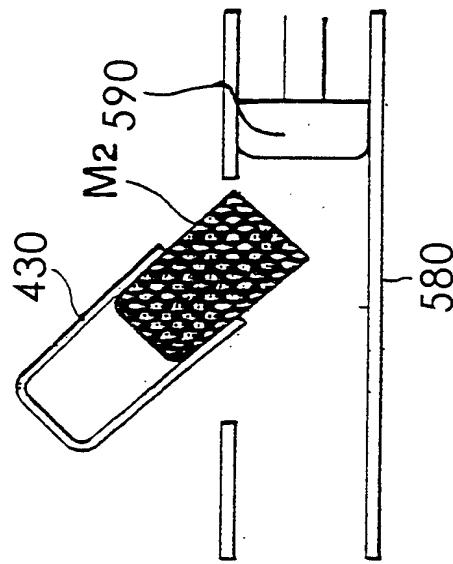
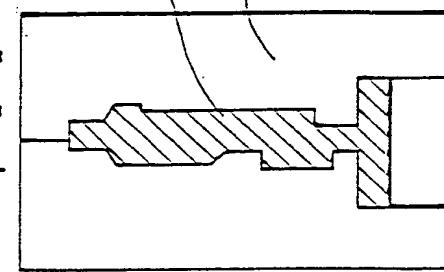


FIG. 80
AC4CH(Al-7Si-0.3Mg-0.15Ti)

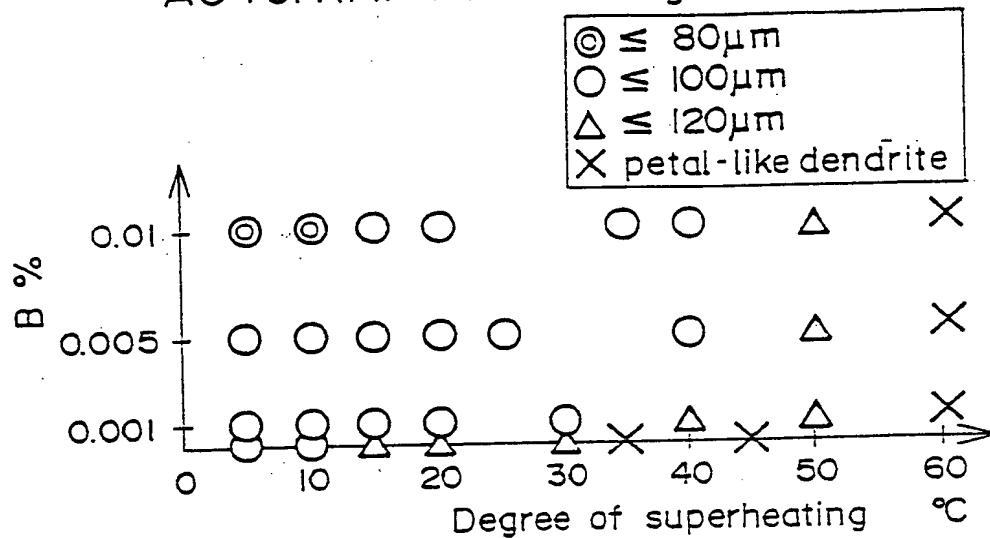
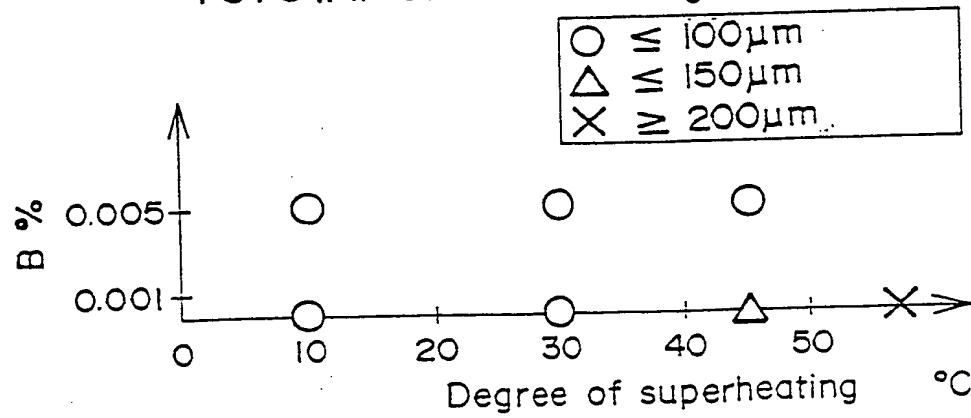


FIG. 81
7075(Al-5.5Zn-2.5Mg-1.6Cu-0.15Ti)



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BY	CLASS SUBCLASS
DRAFTSMAN	

FIG. 82

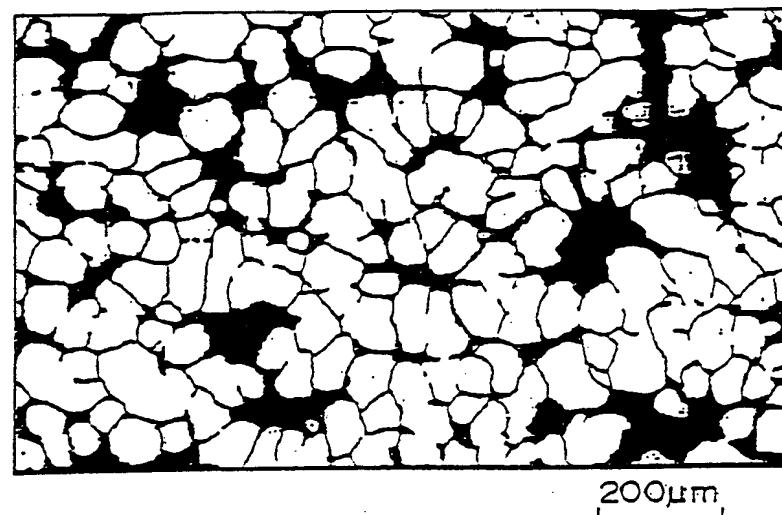
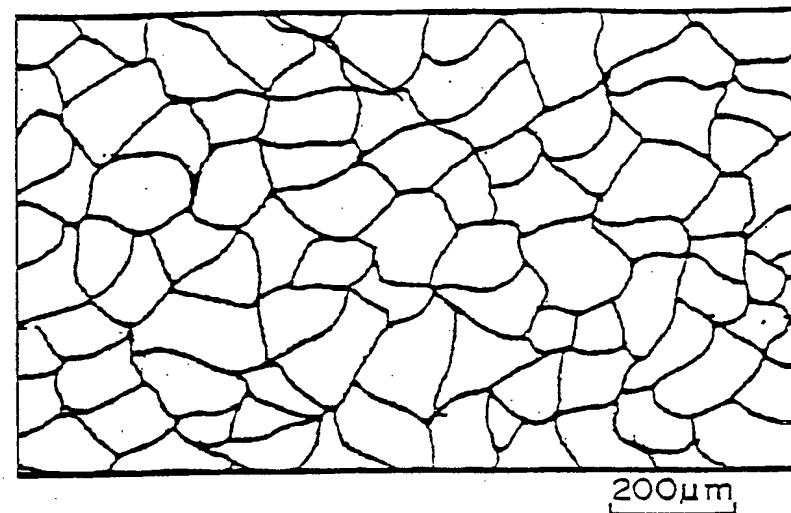
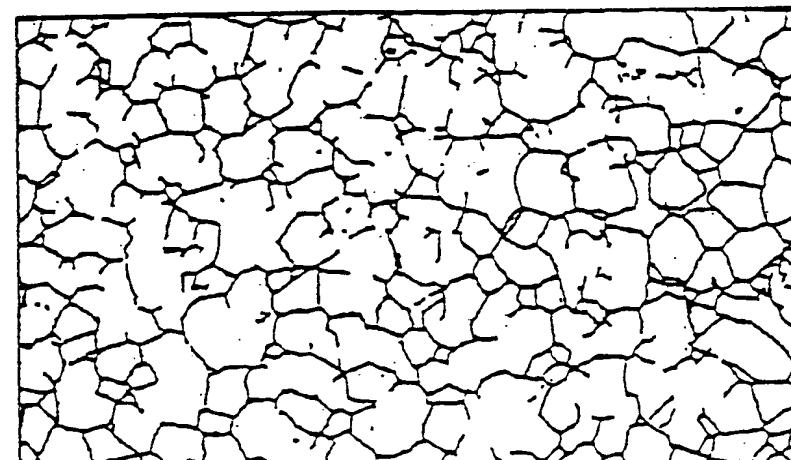


FIG. 83



200 μ m

FIG. 84



200 μ m

FIG. 85 Prior Art

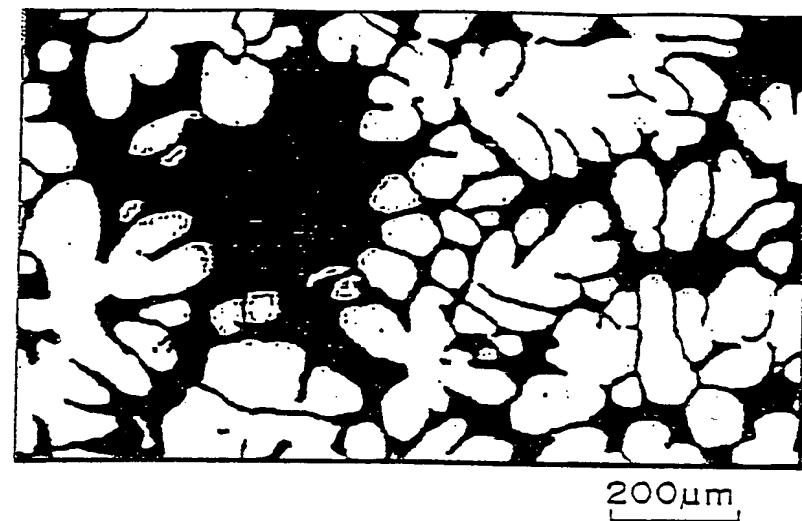


FIG. 86 Prior Art

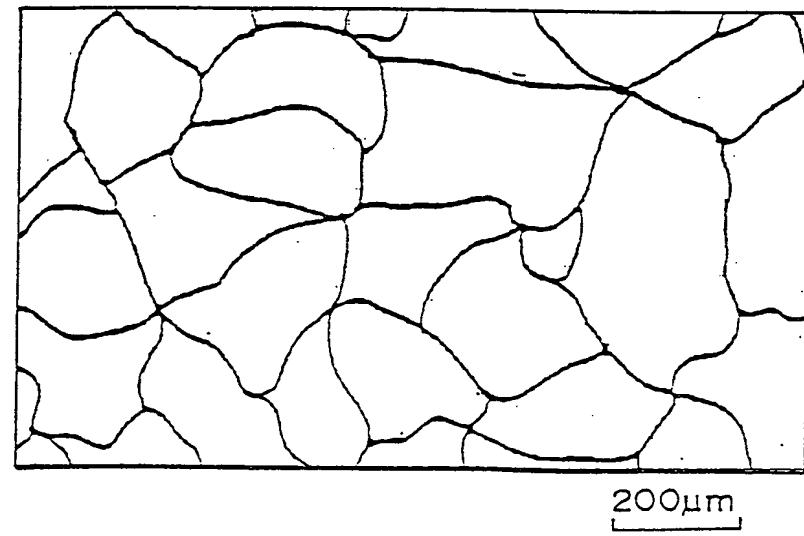


FIG. 87 Prior Art

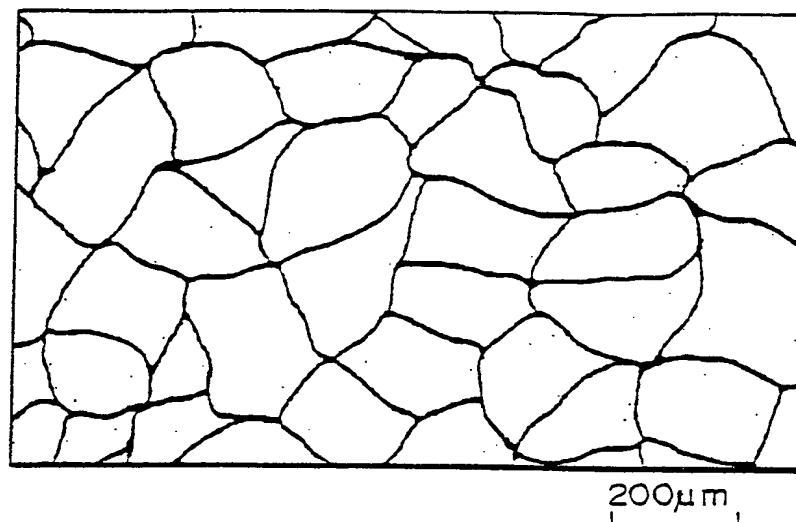


FIG. 88 Prior Art

